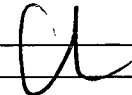


Date: Wednesday, 13/08/2008 9:51:11 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D407-667-205
Job Number	: 41196		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D407667205
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: ECN1225 - REWORK
Prsht Rev.	: NC	Project Number	:
First Issue	: // Type : CROSSTUBES	Drawing Revision	:
Previous Run	: 41182	Material	:
Written By	: 	Due Date	: 20/08/2008 Qty: 1 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:




Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------



Comment: CROSSTUBES RESOURCE 1

PULL FROM STOCK:

1 X D407-667-205 B39427 

ml 08 08 14

2.0	D407667205	Crosstube Aft
-----	------------	---------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Crosstube Aft

ml 08 08 14

3.0	CROSSTUBES	CROSSTUBES RESOURCE 1
-----	------------	-----------------------



Comment: CROSSTUBES RESOURCE 1
 REWORK TUBE PER ECN1225
 MOVE BOTH CHAFING SHIELDS 0.375"
 TOWARD BL 0.0.

ml 08 08 14

(1)

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/21 (X1)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------



Comment: INSPECT FOR ORIGINAL KIT
 TO BE INCLUDED

S 08/08/21 @

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/08/2008 9:51:11 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407-667-205

Job Number: 41196

Part Number: D407667205

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
REPACKAGE USING NEW B/N
@ CHG 006
NEW LABELS REQ'D

JS 08/08/21 (4)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



MF 08-08-21

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D407-667-205	CHG	CHG004
DESC.	Crosstube Aft High	SIC	SH01-5
LOT	B39427	SIC	SR01304NY
MODEL	Bell 407	SIC	

DART Dart Aerospace Ltd. 1270 ABERDEEN ST. HAWKESBURY ONT CANADA K6A 1K7		TC APPROVAL # 09-89 TEL: 1-613-632-5200	
P/N	D407-667-205	CHG	CHG005
DESC.	Crosstube Aft High	SIC	SH01-5
LOT	B41196	SIC	SR01304NY
MODEL	Bell 407	SIC	

MADE IN CANADA

B 41196 D407-667-205

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 08.07.17	Job No.:	ADR Yes/No: <input checked="" type="checkbox"/> Y	ADR Date: 08.07.17	ECN #: 1225
Product No.: D407-667-245		Created By: <i>[Signature]</i>	Approved By: <i>[Signature]</i>	
Product Name: CROSSTUBE ASSY (407 HIGH AFT)		Checked By: <i>[Signature]</i>	General Manager Approval:	

Distribution	Reqd	Resp	Received
Production Manager	Y	LL	
Production Engineering Coord	Y	EC/DD	
Director Quality Assurance	N		
Customer Order Processing	N		

Distribution	Reqd	Resp	Received
Customer Technical Support	Y	DS	
Marketing	N		

Reason for Change:
 REVISED SUPPORT LOCATION ON CROSSTUBE: MOVED EACH SUPPORT 3/8" TOWARD BL0.0 (CROSSTUBE'S CENTERLINE) PER CAR#08-21

Documents Affected:
 RELEASE D407-667-245 REV. E

#	Engineering Actions	Reqd	Resp	Notes	Complete
1	Required Documents/Drawings Under Review	Y	CP		<i>[Signature]</i> 08.02.17
2	Update Blue/Pink/DSI Folder and Electronic Files	Y	KJ		
3	Update D-Part/M-Drawing/DSI/DEO Master Binders	Y	KJ		
4	Update Grey Project Binder	Y	KJ	ADR	
5	Move Electronic Files	Y	KJ		
6	Update Master Document List (MDL)	Y	MB		<i>[Signature]</i> 08.06.07
7	Update Document Record (DR)	Y	KJ		
8	Create/Update Change Record Form	Y	KJ	-205 NOW @ CHG 006 AND -205A @ CHG 004	
9	Create/Update PPP's	Y	KJ	AS REQUIRED	
10	Update Controlled PDF Files	Y	KJ		
11	Notify TC/FAA of Change	N			
12	Update QSI 021 and/or STC Approval List	N			
13	Update Product Development Summary	N			
14	Update Accpac Database	N			
15	Update Access (ARC) Database	N			
16	Update/Verify ARC	N			
17	Update Paperwork Kits in Production	Y	KJ	AS REQUIRED	
18	Update Qpulse/Laminated Dwgs	N			
19	Update Product Compatability Matrix	N			
20	Create Eurocopter Form (FEE)	N			
21					

#	Production Actions	Reqd	Resp	Notes	Complete
22	Create/Update Coss IPP/BOM	Y	EC/DD	AS REQUIRED + SEE BELOW	
23	Update FAI Sheets	Y	EC/DD	AS REQUIRED + SEE BELOW	
24	Create/Update CNC Programs	N			
25	Create/Update Tooling	Y	EC/DD	AS REQUIRED + SEE BELOW	
26	Red Tag Stock (Specify)	Y	JM	PER CAR#08-21	
27	Rework/Scrap Current Production and/or Stock	Y	LL	REWORK AS REQUIRED.	
28	Update Paperwork Kits in Stock	N			
29	Create/Update MPP	Y	EC/DD	AS REQUIRED	
30					

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
31	Notify Previous Customers	N			
32	Notify Eurocopter France	N			
33					

Description / Action:
 TAKE NOTE THAT THE DWG HAS CHANGED CONSIDERABLY TO REFLECT THE LATEST DART'S DWG STDS.
 REVIEW ANY OF THE PRODUCTION'S DOCUMENTS REFERING TO SPECIFIC VIEWS OR CALLOUTS.
 VERIFY NEW LOCATION OF SUPPORTS PRIOR REMOVING THE ABRASION STRIPS. RELOCATE ABRASION STRIPS ONLY IF NECESSARY.

AMENDMENT DESIGN REVIEW (ADR)Part/Installation No.: D407-667-245 Rev: E Design Review No.: _____ Date: 08.07.31Project Number: 00056 Project Description/Title: CROSSTUBEEng. Project Manager: M. BELLAVANCE ASSY (407 HIGH AFT)

Persons Present	Title	Initial
MIKE PETSCHÉ	Design Manager	<i>MP</i>
M. BELLAVANCE	Engineering Project Manager	<i>MB</i>
D. SHEPHERD	Chief Engineer (DE #02)	<i>DS</i>
	Manufacturing Manager	
	Quality Manager	
J. MURDOCH	Q.C. Inspector	<i>JM</i>

Comments

GENE LEBLANC, AIR LOGISTIC'S INSPECTOR, REPORTED THAT THE INNER MOST CLAMPS FASTENING THE CHAFFING SHIELDS INTERFERE WITH THE AIRCRAFT'S ROCKER BEAM MOUNTS (REF. PAR#08-21).

IT WAS DETERMINED THAT THIS INTERFERENCE CAN BE ELIMINATED BY MOVING BOTH CHAFFING SHIELDS 0.375" TOWARD BL 0.0.

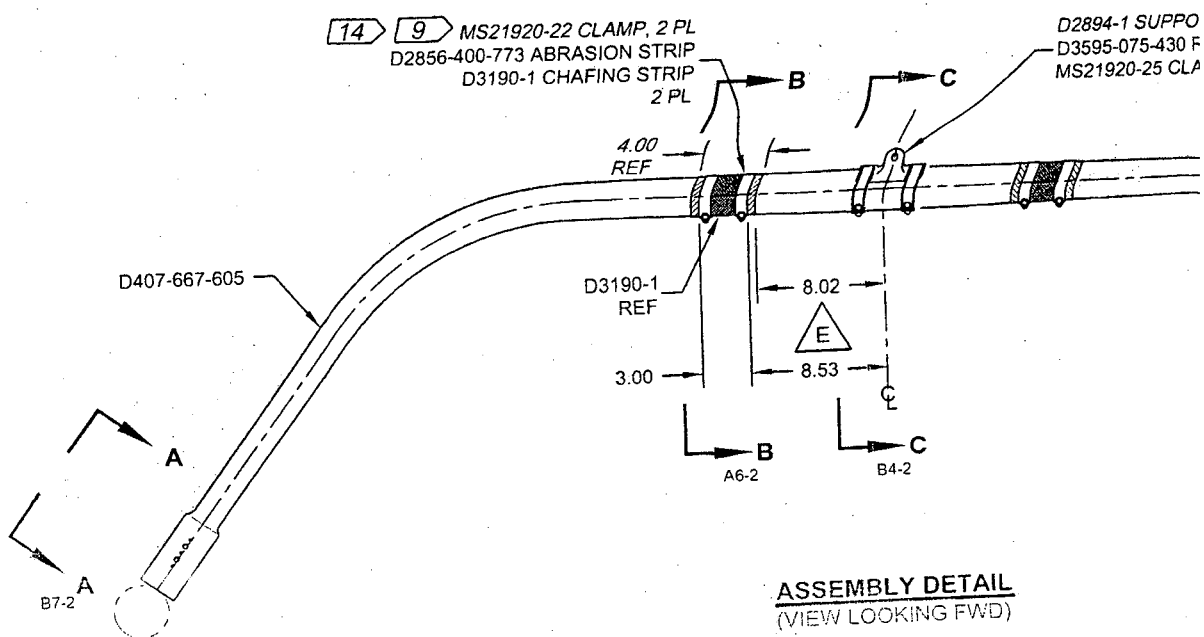
THIS IS A MINOR DIMENSIONAL CHANGE AND APPROVAL BY DE#02 IS ACCEPTABLE.

41182
41195

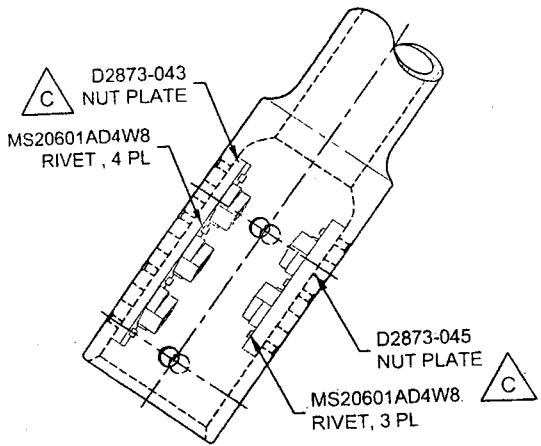
Key Tasks (Check or N/A)	Check	Responsible	Completion Date
Review Outstanding TSR/NCR/CAR/PAR	Y	MP	
Fill out Criteria/Constraints Form – Inputs	N/A		
Fill out Project Evaluation Form	N/A		
D-Part creation/revision	Y	MB	
Get Manufacturing Input	N/A		
First Article Inspection	N/A		
Fit and Function Test	N/A		
Structural Test	N/A		
Reports (Compliance, Loads, Stress, Conformity, DSI)	N/A		
Check Drawings against all QSIs	Y	MB	
Review Criteria/Constraints Form	N/A		
Revision to existing approval	N/A		
Close Amendment Project	Y	MB	

Conclusion:

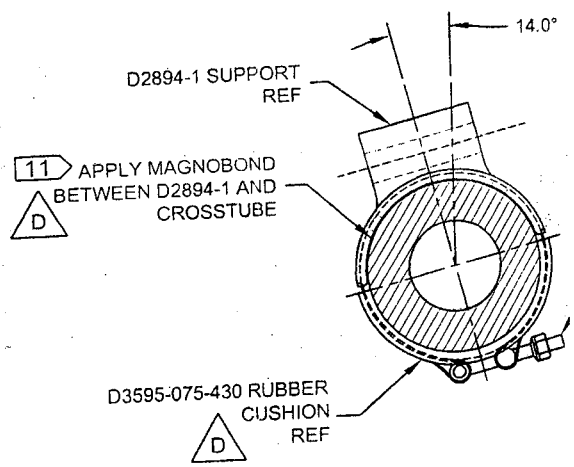
PROCEED WITH THE REVISION OF DRAWING D407-667-245 FROM REV. D TO REV. E AND RELEASE THROUGH ECN#1225.



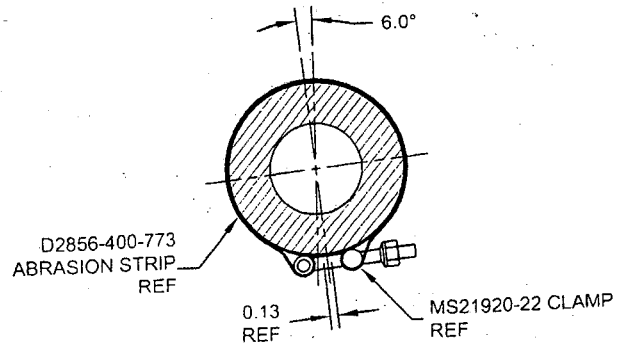
ASSEMBLY DETAIL
(VIEW LOOKING FWD)



VIEW A-A CUFF DETAIL
SCALE 4X

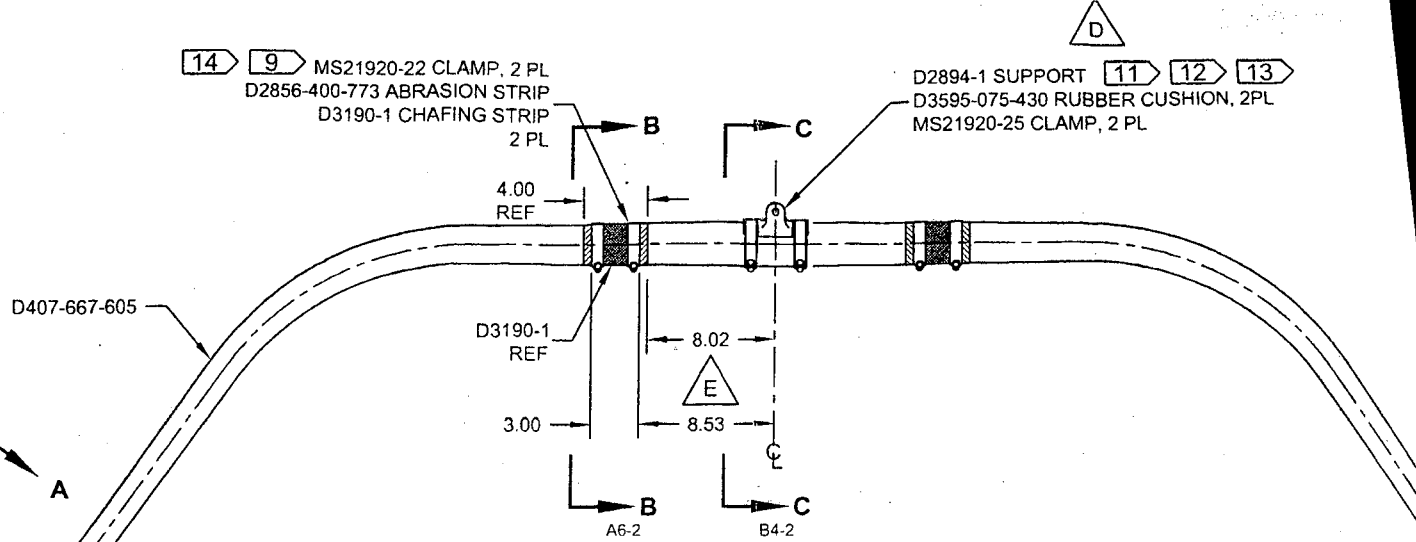


SECTION C-C
SCALE 4X

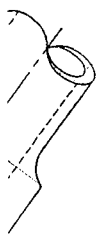


SECTION B-B
SCALE 4X, 2PL

FWD
←

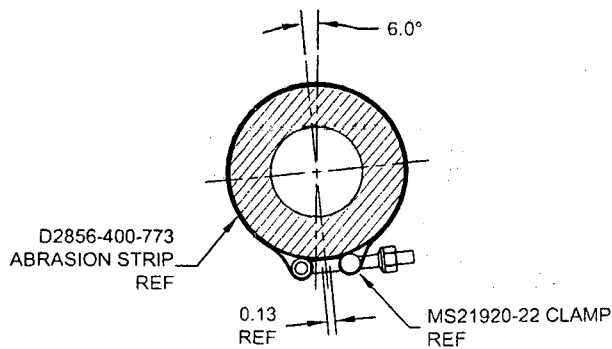


ASSEMBLY DETAIL
(VIEW LOOKING FWD)

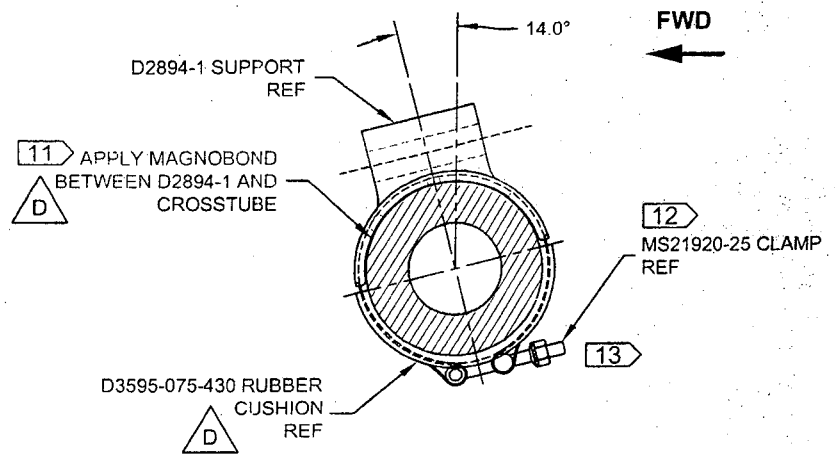


D2873-045
NUT PLATE
301AD4W8
3 PL

CUFF DETAIL
SCALE 4X



SECTION B-B
SCALE 4X, 2PL



SECTION C-C
SCALE 4X

DESIGN
DRAWN
CHECKED
MFG. AP
APPROV
DE APPF
DATE

6

5

4

3

